

Work Order ID 53518

November 6, 2009 4:11:20 PM

Page 1

Item ID: D3120-3

Accept

Setup Start

Revision ID: B

Stop

Item Name: Cover

Start Date: 06/11/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 17/11/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3120

Rev B

110

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D3120

Prog rev:

Dwg rev:

Deburr as required

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

18 9-11-19

18 9-11-19

14

Work Order ID 53518

November 6, 2009 4:11:20 PM



Page 2

Item ID: D3120-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Cover

Start Date: 06/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 17/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

27 502/11/19

414

1



QC

Memo

0.00

Quality Control

135

Brake NC

0.00

27 10/11/12

13

Pho =>



Brake NC

Memo

0.00

Brake NC

1- deburr if necessary
2-bend as per dwg

136

QC5- Inspect part completeness to step on W/O

0.00

5 10/02/22

43

-3



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3120-3 PAR #: _____ Fault Category: Small FAB NCR: Yes No DQA: _____ Date: 10/03/16
 Resolution: SCVAP Disposition: Scrap QA: N/C Closed: _____ Date: 10/03/16

NCR: <u>53518</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/02/11</u>	<u>B5</u>	<u>1 part material broke. The small Tangy section R.C process</u>	<u>[Signature]</u>	<u>Scrap & destroy No-replace</u>	<u>S</u> <u>10/01/11</u>	<u>S</u> <u>10/02/12</u>	<u>[Signature]</u>	<u>S</u> <u>10/02/22</u>

NOTE: Date & initial all entries

Work Order ID 53518

November 6, 2009 4:11:20 PM



Page 3

Item ID: D3120-3	Accept		Setup	Start	
Revision ID: B				Stop	
Item Name: Cover					
Start Date: 06/11/2009	Start Qty: 4.00		Cust Item ID:		
Required Date: 17/11/2009	Req'd Qty: 4.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	BL	10-02-22		(13)			
150 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 11/12588 Memo START TIME: 3:50 320° FINISH TIME: 4:20 OVEN TEMPERATURE:	0.00 0.00	BL	10-02-22		(13)			
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	JH	10/02/23		(X15)	Ø		

Work Order ID 53518

November 6, 2009 4:11:20 PM



Page 4

Item ID: D3120-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Cover

Start Date: 06/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 17/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: 181

0.00



Packaging

Memo

0.00

Packaging

PC 12/3/09 (13)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/02
CY 03/01/10

11

Picklist Print

November 6, 2009 4:11:28 PM

Page 1

Work Order ID: 53518

Parent Item: D3120-3RevB

Parent Item Name: Cover

Comments:

Start Date: 06/11/2009

Required Date: 17/11/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			110	sf	203.3122	0.9175	3.3		



2024-T3 .032 sheet

B9-11-19

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

203.3122316

102942

1.5

105555

4.0684

106272

5.3

108595

1.2

109240

7.02

110305

144

110778

18.8996316

111699

18.3242

18147

3

106272 x 4

111699 x 8

(14)

DART AEROSPACE LTD		Work Order:	53518
Description: Cover		Part Number:	D3120-3
Inspection Dwg: D3120	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

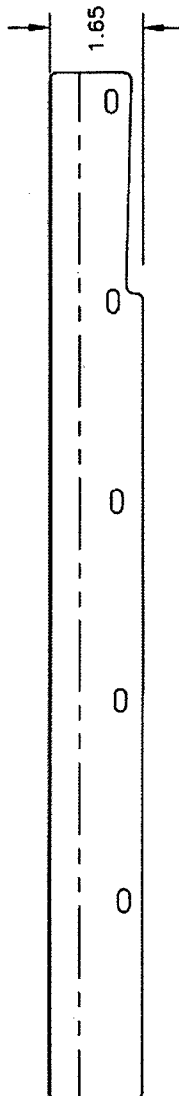
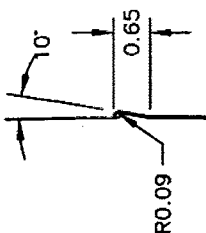
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.201 x 0.400	+0.005/-0.001 x +/-0.010	0.201 x .400	✓			
0.642	+/-0.010	.640	✓			
2.651	+/-0.010	2.652	✓			
0.150	+/-0.010	.145	✓			
1.67	+/-0.030	1.670	✓			
1.29	+/-0.030	1.291	✓			
1.00	+/-0.030	1.001	✓			
1.127	+/-0.010	1.125	✓			
13.125	+/-0.010	13.128	✓			
3.281	+/-0.010	3.277	✓			
17.90	+/-0.030	17.80	✓			
18.331	+/-0.010	18.331	✓			
0.032	+/-0.010	.033	✓			

Measured by: <u>JB</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>9-11-19</u>	Date: <u>09/11/19</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.21	New Issue	KJ <u>AF</u>	<u>M</u>



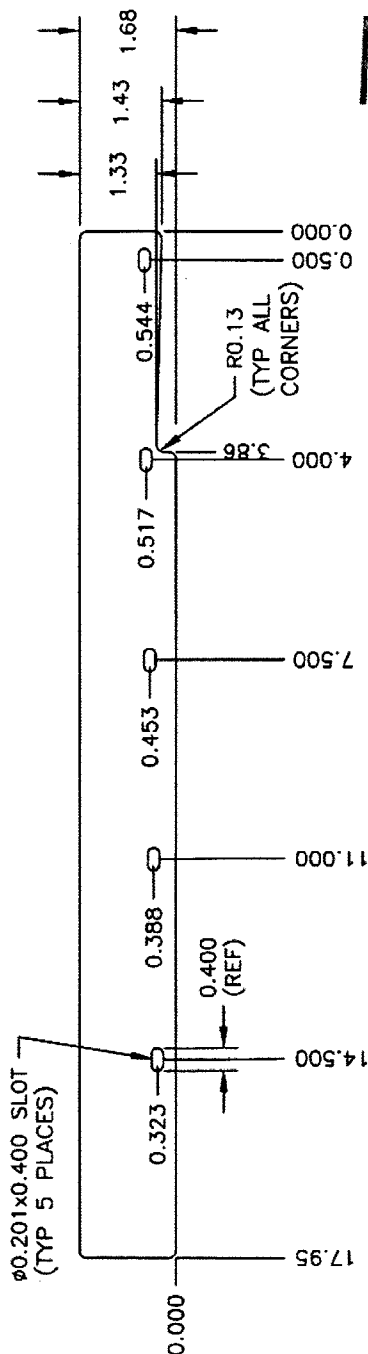
DESIGN #	DRAWN BY KF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3120	REV. B SHEET 1 OF 2
DATE 04.10.18		TITLE COVER	SCALE NTS
A	02.04.15	NEW ISSUE	
B	04.10.18	ADD PART MARKING	



BEND DETAIL

D3120-1 COVER (BEND AS SHOWN. REPLACES PREMIER P/N B30-23000-229)
D3120-2 COVER (BEND OPPOSITE. REPLACES PREMIER P/N B30-23000-230)

UNCOM
SUB
V
V
NO. 585/8



RELEASED
04.11.23

D3120-1/-2 COVER. FLAT PATTERN

D3120-1/-2 NOTES

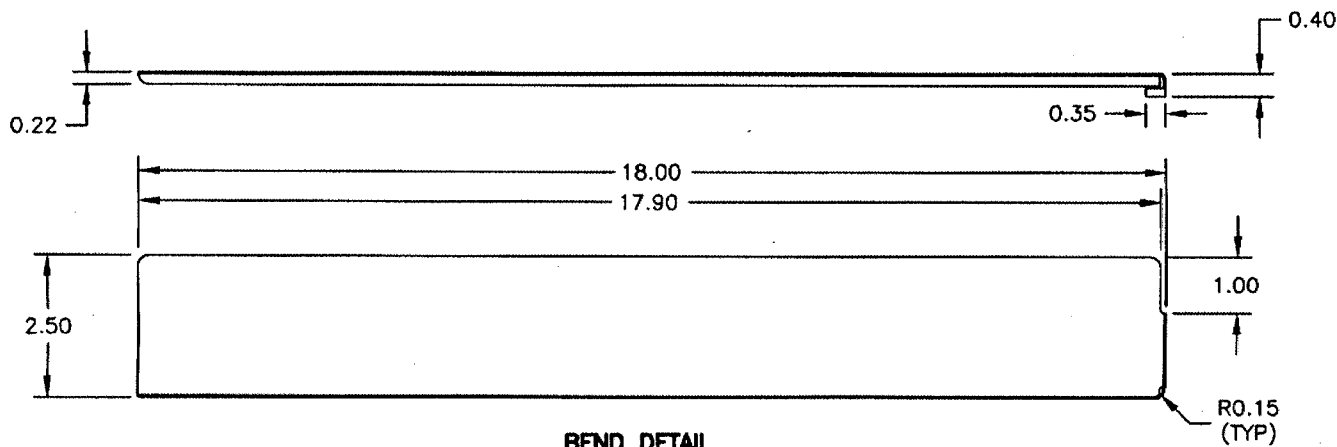
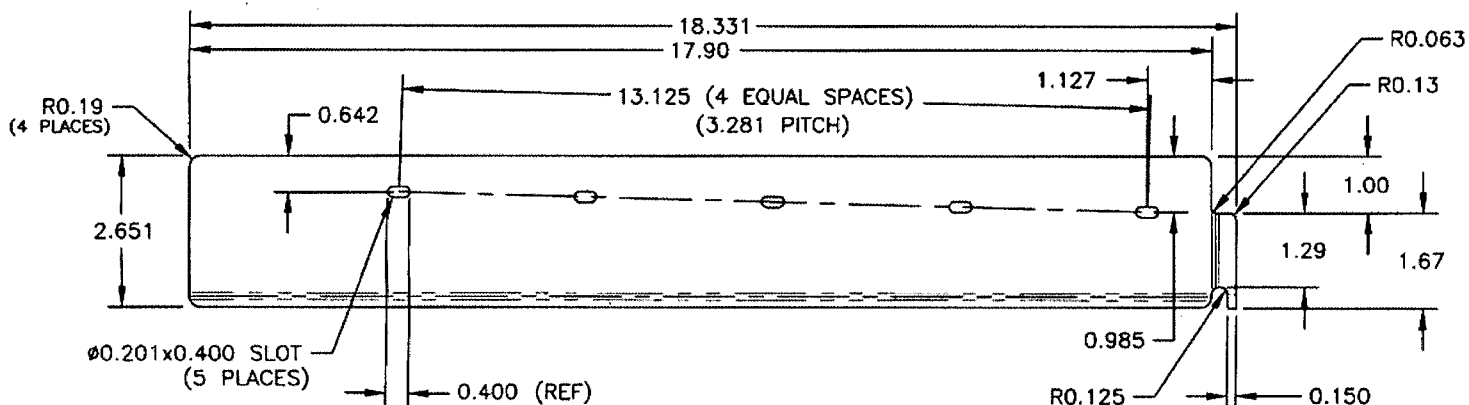
- 1) MATERIAL: 2024-T3 (QQ-A-250/4), 0.032 THICK (REF DART SPEC. M2024T3S.032)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER ON INSIDE SURFACE

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
04.10.18	D3120	SHEET 2 OF 2
	TITLE	SCALE
	COVER	NTS

**BEND DETAIL****D3120-3 COVER (BEND AS SHOWN. REPLACES PREMIER P/N B30-23000-231)****D3120-4 COVER (BEND OPPOSITE. REPLACES PREMIER P/N B30-23000-232)****D3120-3/-4 COVER. FLAT PATTERN****D3120-3/-4 NOTES**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4), 0.032 THICK (REF DART SPEC. M2024T3S.032)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER ON INSIDE SURFACE

RELEASED
04.10.18

53516